



Dart Aerospace Ltd.
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D3213-1
Job Sheet 178564



Part No: D3213-1

Job Qty: 6 ea

Part Name: Door Panel



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/1/18

Job Tracking No:

Due Date: 6/22/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 05-11-17 New Issue JLM IPP Rev:B 07-02-13 Now on Waterjet JLM IPP Rev C:
08.11.26 Comment added to step 2 KJ Verified by: EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	6/22/18	6/22/18	0.00	0.00	Start Up Waterjet		SC 13/06/15
100	Waterjet	6 pcs	6/22/18	6/22/18	0.00	0.46	Waterjet1		SC 13/06/15
120	QC	6 pcs	6/22/18	6/22/18	0.00	0.00	QC8		38
130	Small Fab	6 pcs	6/22/18	6/22/18	0.00	0.00	Small Fab-3	N/A	9-88
140	HandFinish	6 pcs	6/22/18	6/22/18	0.00	0.28	HandFinish1		SA 18/06/18
150	QC	6 pcs	6/22/18	6/22/18	0.00	0.00	QC3		38
160	Packaging	6 pcs	6/22/18	6/22/18	0.00	0.00	Packaging3		3-88
170	QC21-SA	6 Ea	6/22/18	6/22/18	0.00	0.00	QC21		21

Part Op 100 - 1-Cut as per Dwg D3213
Descriptions: 130 - Deburr

DAS 6 JUN 26 2018
9-88
21
9-88 JUN 27 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.063	2024-T3 .063 Sheet	2.8284 sf (.4714 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M2024T3S.063	3	221	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Door Panel	15.000inches ± 0.030	15.030 14.970	15.000	
2	Door Panel	4.470inches ± 0.030	4.500 4.440	4.474	
3	Door Panel	14.400inches ± 0.005	14.405 14.395	14.402	
4	Door Panel	0.300inches ± 0.010	0.310 0.290	0.301	
5	Door Panel	0.128inches + 0.005 - 0.001	0.133 0.127	0.129	
6	Door Panel	2.057inches ± 0.005	2.062	2.055	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only



DISPOSITION		AGAINST DEPARTMENT/PROCESS			
Work Order: _____	Rework	Skid-tube	Cross tube	Water Jet	Engineering
Part No. _____	Scrap	Machining	Small Fab	Prod. Eng. Coord.	Quality
NCR No. _____	Use-as-is	Thermoforming	Finishing	Rec/Store/Packaging	Other
Date : _____	Suspected Unapproved	Large Fab	Composite	Supplier	MRB (QS1042) Approval
Step #: _____		QTY Effective : _____			
Description Work Order Deviation					
Disconnection					
Container No: S081651					
Part: D3213 - 1					
Job No: 178564					
Serial No/Batch: S081651					
Revision: _____					
Inspector: _____					
Exp Date: _____					
Instructions: _____					
Date: 06/15/18					
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CANADA					
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www.dartaerospace.com					
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Part Moved					
Drawing					
Finish					
Misread					
Turning Sequence					
Off-set					
Mislabeled					
Fit/Function					
Misaligned/off center					
Cut Too Short					
Instructions Incomplete/Unclear					
Drill Holes					
OTHER : _____					
Root Cause					
No Re-verification					
Operator					
Offset/Setup					
Supplier					
Training					
Use for Testing					
Poor Information					
Rushing					
Product Improvement					
Process Improvement					
Manufacturing Process					
Past Due					
Environment					
Design					
Doc/Data					
Equip/Tooling					
Handling/Pre					
Material					
Internal Transport					
Tribal Knowledge					
LOA					
Substation					
Past Expiry Date					
Misidentified					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					